

Date: Thursday, 2/9/2006 1:49:38 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BEARPAW KIT (19"X48")
Job Number	: 25768		
Estimate Number	: 10768		
P.O. Number	: N/A	Part Number	: K10015
This Issue	: 2/9/2006	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D2521 REV I
First Issue	: N/A	Project Number	: N/A
Previous Run	: 24834	Drawing Revision	: I
	Type : MACHINED PARTS	Material	: N/A
Written By	: <u>See Comment Below</u>	Due Date	: 2/25/2006
Checked & Approved By	: <u>KJ 06.02.10</u>	Qty:	10 Um: Each
Comment	: Est Rev:D 05.06.20 Forming removed KJJ/JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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## Comment: DOCUMENT CONTROL

Photocopy bluefile:

K10015

D205-564-011

D430-688-011

and create labels per PPP K10015 CHG002

(Bag Bluefiles separately)

KJ 06-02-23

12

2.0	MUHMWB10	UHMW 1" Black
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Comment: Qty.: 13.6500 sf(s)/Unit Total : 136.5000 sf(s)  
 blank: 19.500" x 48.0" x 1.00" thick (+0.030/-0.000) per DSK086-6  
 Material: Black UHMW 1"  
 (MUHMWB10)  
 Batch: M19541

JF 06/03/13 10

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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## Comment: HAAS CNC VERTICAL MACHINING #1

(2) Bearpaws Make (1) kit

1-Inspect material for defects or damage prior to machining

2-Machine as per Folio and Dwg D2521 Identify as D2432F

3-Deburr

JL 06/03/14 10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 2/9/2006 1:49:38 PM  
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Drawing Name: BEARPAW KIT (19"X48")

Job Number: 25768

Part Number: K10015

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*ml 06/03/15 10*

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

*Er 06/03/24 10*

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

7.0

D2182B

Neoprene Cushion-.750 bl



Comment: Qty.: 0.4583 f(s)/Unit Total : 4.5830 f(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 D2182B055

Rubber Cushion

*B23122 13 mcy B24870 59 mcy*

8.0

D2274

Radius Block



Comment: Qty.: 16.0000 Each(s)/Unit Total : 160.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

16 D2274

Radius Block

2 D2521(ref only)

Bearpaw

*B25223 156 mcy 4 mcs B23372  
B25768*

9.0

D2529

Washer



Comment: Qty.: 16.0000 Each(s)/Unit Total : 160.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

16 D2529

Washer

*B25372*

10.0

D2947

Clamp



Comment: Qty.: 8.0000 Each(s)/Unit Total : 80.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 D2947

Clamp

*B23188*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: Q Date: 06/03/30  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 2/9/2006 1:49:38 PM  
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Drawing Name: BEARPAW KIT (19"X48")

Job Number: 25768

Part Number: K10015

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

AN415A

Bolt



Comment: Qty.: 16.0000 Each(s)/Unit Total : 160.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

16 AN4-15A Bolt M19085

160

12.0

AN960JD416

Washer



Comment: Qty.: 16.0000 Each(s)/Unit Total : 160.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

16 AN960JD416 Washer M19085

160

13.0

MS21042L4

Nut



Comment: Qty.: 16.0000 Each(s)/Unit Total : 160.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

16 MS21042L4 Nut (or -4) M19099

160

P 6/3/27 (10)

14.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

C206/03/29 (10)

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPPK10015

Location: \_\_\_\_\_

REV.D

C206/03/29 (10)

16.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SP 06/03/30 (10)

Job Completion



h 06/03/29

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng		Action Description Chief Eng				Sign & Date

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	25768
<b>Description:</b> Bearpaw		<b>Part Number:</b>	D2521
<b>Inspection Dwg:</b> D2521 <b>Rev:</b> I		<b>Page 1 of 1</b>	

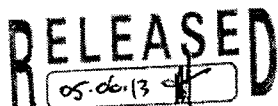
### FIRST ARTICLE INSPECTION CHECKLIST





☒ **First Article**
         
 ☐ **Prototype**

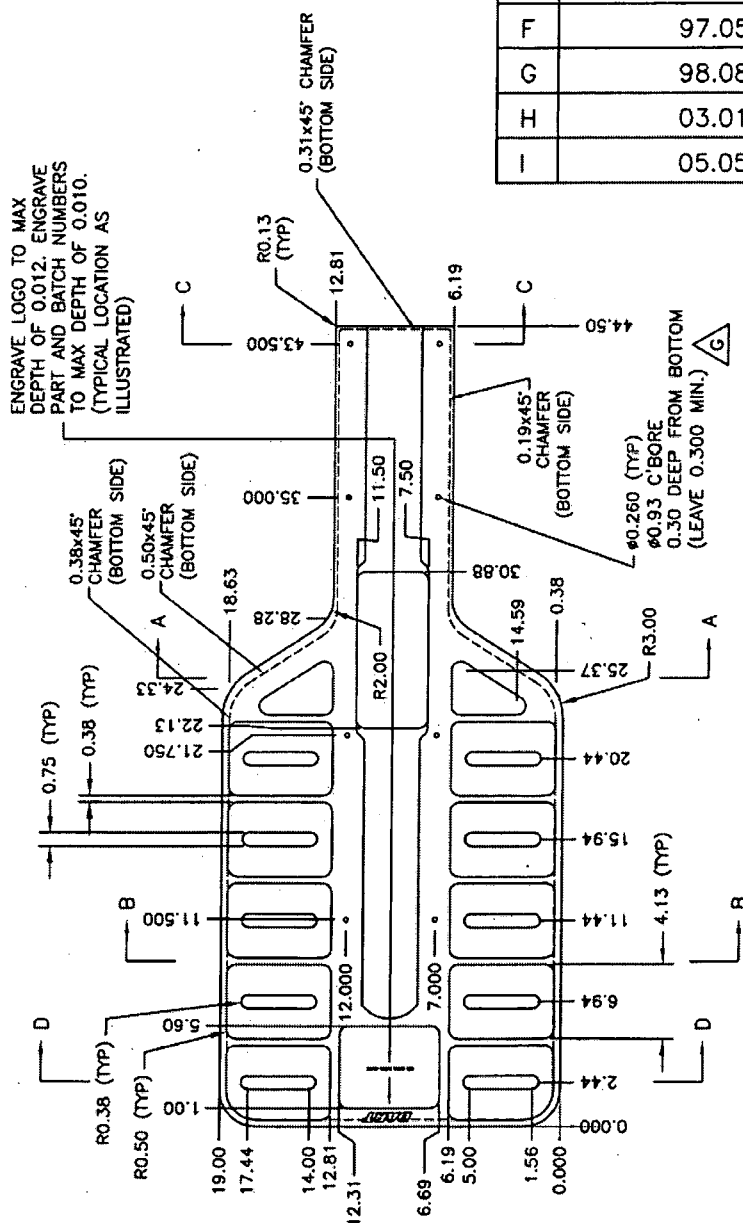
Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	1.00	+/-0.030	1.004	✓			
B	5.60	+/-0.030	5.600	✓			
C	11.50	+/-0.030	11.500	✓			
D	10.250	+/-0.010	10.250	✓			
E	13.250	+/-0.010	13.250	✓			
F	8.500	+/-0.010	8.500	✓			
G	22.13	+/-0.030	22.130	✓			
H	8.75	+/-0.030	8.755	✓			
I	44.50	+/-0.030	44.500	✓			
J	6.69	+/-0.030	6.687	✓			
K	5.63	+/-0.030	5.622	✓			
L	7.000	+/-0.030	7.000	✓			
M	5.000	+/-0.010	5.000	✓			
N	4.00	+/-0.030	4.003	✓			
O	6.63	+/-0.030	6.628	✓			
P	19.00	+/-0.030	19.000	✓			
Q	0.31 x 45°	+/-0.030	0.290 x 45°	✓			
R	0.19 x 45°	+/-0.030	0.180 x 45°	✓			
S	0.50 x 45°	+/-0.030	0.500 x 45°	✓			
T	0.38 x 45°	+/-0.030	0.373 x 45°	✓			
U	0.063 x 45°	+0.030/-0.010	0.060 x 45°	✓			
V	Ø0.260	+0.005/-0.000	Ø0.260	✓			
W	Ø0.93	+/-0.030	Ø0.928	✓			
X	0.30	+0.030/-0.010	0.295	✓			
Y	0.37	+0.030/-0.010	0.370	✓			
Z	0.75	+0.030/-0.010	0.775	✓			
AA	0.25	+0.030/-0.010	0.270	✓			
AB	4.00	+/-0.030	4.003	✓			
AC	6.62	+/-0.030	6.629	✓			
AD	0.95	+0.030/-0.010	0.958	✓			
AE	0.37	+0.030/-0.010	0.370	✓			
AF	3.40	+0.030/-0.010	3.400	✓			
AG	6.63	+/-0.030	6.630	✓			

<b>Measured by:</b>	Jnl	<b>Audited by:</b>	MS	<b>Prototype Approval:</b>	N/A
<b>Date:</b>	06/03/14	<b>Date:</b>	06/03/14	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue      P/O K10015	KJ/RF	
B	05.06.15	Dimensions and tolerances changed	KJ/RF	



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CHECKED		APPROVED		DRAWING NO.	REV. 1
DATE			TITLE		SHEET 1 OF 2
05.05.20			205 BEARPAW		SCALE 1:10
A	95.11.28	NEW ISSUE			
B	96.01.11	SHOW BENDING MOVE HOLES			
C	96.01.29	ADJUST HOLE LOCATION FOR TOOLING			
D	96.05.14	ADJUSTED BEAR PAW THICKNESS			
E	96.12.18	43.500 WAS 46.750			
F	97.05.07	ADDED REAR POCKET, MOVED HOLES			
G	98.08.06	ADD C'BORE AND CHAMFER EDGES			
H	03.01.30	CHANGE GEOMETRY FOR RUN-ON LDG.			
I	05.05.20	REMOVE BEND; CHANGE TOLERANCES			



NOTES:  
 1) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689, 1.00 THICK (MACHINE TO 0.950)  
 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
 3) ALL DIMENSIONS ARE IN INCHES





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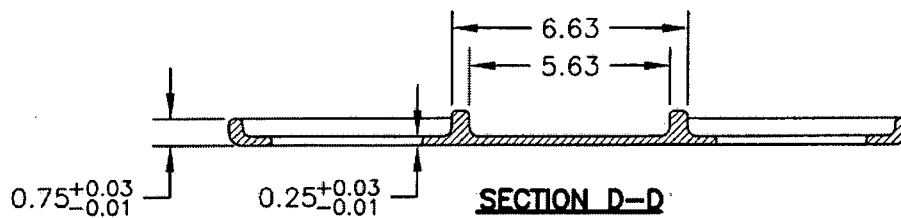
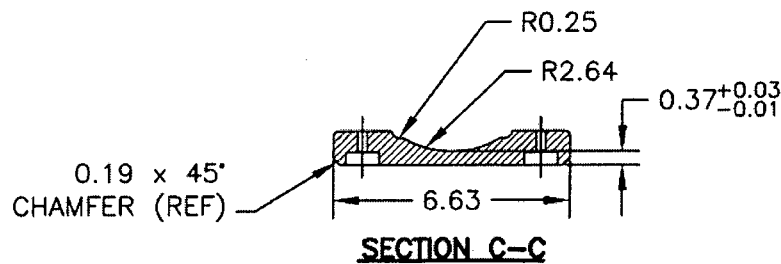
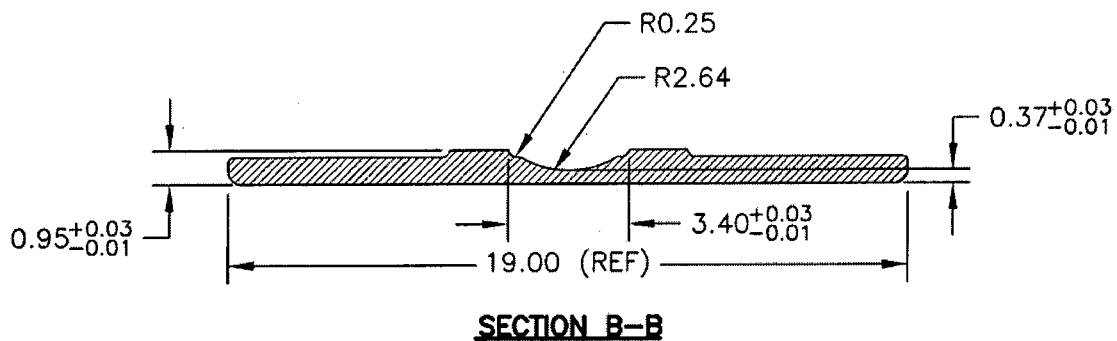
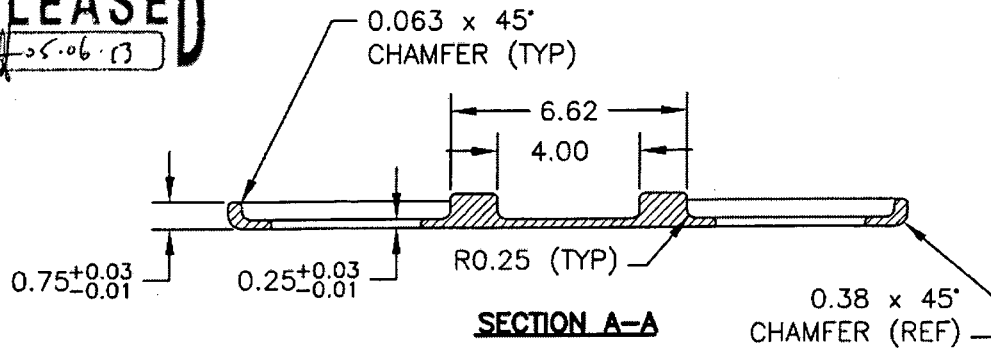
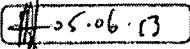
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CHECKED 	APPROVED 	DRAWING NO. D2521	REV. 1 SHEET 2 OF 2
DATE 05.05.20		TITLE 205 BEARPAW	SCALE 1:5

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